

113958

113958

February-28-14 7:42:05 AM

Item ID: D350-636-018 Accept *N900040100* Setup Start *NS1*

Revision ID: Stop *NS2*

Item Name: Skidtube RH Run-On Landing Wearplates Air Cruiser / Apical Tri-Bag Float Compatible

Start Date: 2/28/14 Start Qty: 1.00 *1* Cust Item ID:

Required Date: 3/14/14 Req'd Qty: 1.00 *1* Customer:

Reference:

Approvals: Process Plan: MLJ Date: 1402-28 Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D4168-044	B
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100	Document Control	0.00
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100

DC	Memo	0.00
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Doc.Control -USB or Paperwork

Photocopy blue file and type labels per PPP D350-636-018 CHG 005

N/A MLJ 1407-07

89.3°
DP 14-3-18

Work Order ID 113958

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Page 2

Item ID: D350-636-018**Accept*****N900040100*****Setup Start *NS1*****Revision ID:****Stop *NS2*****Item Name:** Skidtube RH Run-On Landing Wearplates Air Cruiser / Apical Tri-Bag Float Compatible**Start Date:** 2/28/14 **Start Qty:** 1.00 ***1*****Cust Item ID:****Required Date:** 3/14/14 **Req'd Qty:** 1.00 ***1*****Customer:****Reference:****Approvals:** **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____**Run Start *NR1*****QC:** _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____**Stop *NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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110

0.00

110

Skidtubes

Skidtubes

Memo

0.00

1- Pick D2600-3 Bent

DP 14-3-18

2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside
AFT end per dwg D4168

14/3/19 JCC/m

3- Drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500",
deburr.4- Locate DT8329 off of blade fitting bolt holes and drill pilot holes for blade
fitting

5- Drill fwd step holes using DT9616 detail AA . Ensure proper positioning.

6- Drill pilot holes using drill Jig DT8150 & DT8864A for first side only
DT8864B for second side section BE-BE and BC-BC7- Clecko DT8864B on second side of tube and drill pilot holes for section BE-
BE and BC-BC ***SECOND SIDE***

DP 14-3-18

8-Drill pilot holes for wearplates as per Dwg D4168 using DT9678. Locating
from 66.54" holes.9-Open up holes of Detail A to 0.297" (total of 2 holes per side) +.201" holes
Detail AA.10-Weld D2744 Cap as per Dwg D4168 and QSI 004.Fill grooves in bend left
from bending as per QSI 004

A/R Aluminum Rod batch: M127763

BE1403-19

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Item ID: D350-636-018**Accept*****N900040100*****Setup Start *NS1*****Revision ID:****Stop *NS2*****Item Name:** Skidtube RH Run-On Landing Wearplates Air Cruiser / Apical Tri-Bag Float Compatible**Start Date:** 2/28/14 **Start Qty:** 1.00 ***1*****Cust Item ID:****Required Date:** 3/14/14 **Req'd Qty:** 1.00 ***1*****Customer:****Reference:****Approvals:** **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____**Run Start *NR1*****QC:** _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____**Stop *NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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11-Grind welds flush as per Dwg D4168

BE14-03-19

120

QC10- Inspect visual per QSI004- ground welds 0.00

120

QC

Memo

Quality Control

① 14-03-20 **DAS**
9
9-89

130

QC5- Inspect part completeness to step on W/O 0.00

130

QC

Memo

Quality Control

① 14-03-20 **DAS**
9
9-89

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Item ID: D350-636-018

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N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

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Start Date: 2/28/14 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 3/14/14 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Chemical Conversion Coat per QSI005 4.1	0.00							
140									
HandFinish	Memo	0.00							
Hand Finishing									
150	QC7-Inspect Chemical Conversion Coat	0.00							
150									
QC	Memo	0.00							
Quality Control									

14-3-24 DGL/JLL

① / DL14/03/24

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Start Date: 2/28/14 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 3/14/14 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Skidtubes	0.00							
160		0.00							
Skidtubes	Memo								
Skidtubes	1-Open up holes of Detail AB and ground handling to 0.625" (total of 8 holes per side) as per dwg D4168.								
	2-Open up holes of wearplate holes to 0.375" section CK-CK (total of 4 holes per side) 0.3125" holes section BC-BC (4 per side) as per dwg D4168.								
	3- Open float hole to 0.500" (4 per side)								
	4-Chamfer holes dwg D4168 (welding instructions on sheet 11)								
	5-Deburr and blow out all chips from inside of tube								
	6- Prepare tube for welding, remove alodine as required.								
	7-Bond web D2739 in place as per QSI 015 A/R Sikaflex-291 batch: <u>23076</u> exp. date: <u>14-10-09</u>								
	8- Weld spacers as per dwg D4168 & QSI004 (welding instructions on sheet 11) A/R Aluminum Rod batch: <u>m127763</u>								
	9- Grind welds flush as per Dwg D4168								
	10-Spot face ground handling holes section (total of 4 places per side) as per dwg D4168								

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Item ID: D350-636-018

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N900040100

Setup Start ***NS1***

Revision ID:

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Item Name: Skidtube RH Run-On Landing Wearplates Air Cruiser / Apical Tri-Bag Float Compatible

Start Date: 2/28/14 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 3/14/14 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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11- C'bore section CK-CK. ADJUST TOOLING AS REQUIRED.
VERF BY: BE

BE
14-03-20

✓ 12- Deburr holes 14-3-26 DEL

***** FOR DELUXE SKIDTUBE IF APPLICABLE DRILL TOW RING
HOLE IN TUBE *****
***** REF TO W/O BATCH: 112360 *****

170 QC10- Inspect visual per QSI004- ground welds 0.00

170

QC Memo 0.00

Quality Control

①

14-03-27

DAS
9
9-89

180 QC5- Inspect part completeness to step on W/O 0.00

180

QC Memo 0.00

Quality Control

①

14-03-27

DAS
9
9-89

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N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

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Start Date: 2/28/14

Start Qty: 1.00

1

Cust Item ID:

Required Date: 3/14/14

Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Run Start ***NR1***Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

Pressure Wash per QSI005 4.3

0.00

100

HandFinish

Memo

0.00

Hand Finishing

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

1 AK 14-3-31

200

0.00

200

SprayPaint

Memo

0.00

Spray Painting

1- PRIME AS PER DWG AND QSI 005 4.2
PRIMER PRC DESOTO 515X349 BATCH: 1271082- PAINT WHITE AS PER DWG AND QSI 005 4.2
PAINT BATCH: 1285741 CA 14-03-31

210

QC14- Inspect Spray Paint

0.00

210

QC

Memo

0.00

Quality Control

Inspect for foreign object per QSI 024

DAS
27
9.39
4/3/14

Work Order ID 113958

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Page 8

Item ID: D350-636-018

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N900040100

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Start Date: 2/28/14 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 3/14/14 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230	HandFinishing	0.00							
230	HandFinish	0.00							
Hand Finishing	Memo								
	1- Install inserts as per Dwg D4168								
	2-Inspect for Foreign Objects								
	3-Install blade fitting D3488-041, wearshoes and ground handling hardware as per dwg D2750								
	SIKA FLEX 241								
	BATCH: 114129057								
	EXP DATE: 14/11								
	4-assemble o'ring to plug as per dwg D3492 and apply o'ring lube								
	A/R 55-o'ring lube batch: 14121651 127054813411 1125792 241:15/04								
	5-Coat all exposed fasteners with "LPS Procyon" batch: 14127906								
240	QC5- Inspect part completeness to step on W/O	0.00							
240	QC	0.00							
Quality Control	Memo								

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Start Date: 2/28/14 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 3/14/14 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
250	Pick Kit	0.00							
250									
Packaging	Memo	0.00				1X		14-7-2	DAS 28 9-89
Packaging									
260	QC4- 100% Inspect kits for completeness	0.00							
260									
QC	Memo	0.00			DAS 31 9-89	L		14-07-02	
Quality Control	*****ensure antiseize is on AN8C21A bolts*****								
270		0.00							
270									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPPD350-636-018								
	Location: _____								
	PPP rev: _____								

JUL 02 2014

DAS
06
9-89

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1 13958

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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280	QC21- Final Inspection - Work Order Release	0.00							
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280

QC

Memo

0.00

Quality Control

MLS 14-07-07

JMF
14-7-04

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence
		<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge
		<input type="checkbox"/> Pressure/Forced Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other

Picklist Print

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Work Order ID: 113958

113958

Parent Item: D350-636-018

D350-636-018

Parent Item Name: Skidtube RH Run-On Landing Wearplates Air Cruiser / Apical Tri-Bag Float Compatible

Start Date: 2/28/14

Required Date: 3/14/14

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP rev:A 10.09.28 new issue DD verf:EC IPP Rev:B
11.04.14 ecn11-553 DD verf:EC IPP Rev:C 11.10.18 as per
NCR 11-906 DD verf:EC IPP Rev:D 112.04.16 AS PER ECN 12-
542 DD verf:EC IPP REV:E 13.08.28 PER ECN13-594 DD
VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D3490-1		Manufactured	No			160	Each	145.0000	4	4			
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D3490-1

Cross Bolt Spacer

**

BE14-03-25

Location	Loc Qty	Loc Code
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LG	57	
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112737	57	
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LG001	88	
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107419	4	
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109932	84	
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AN3C34A		Purchased	No			230	Each	47.0000	1	1			
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AN3C34A

BOLT

**

14-7-2

DAS
31
9-89

Location	Loc Qty	Loc Code
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ST352	47	
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m127044	47	
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DAS
26
9-89

Picklist Print

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Work Order ID: 113958

113958

Parent Item: D350-636-018

D350-636-018

Parent Item Name: Skidtube RH Run-On Landing Wearplates Air Cruiser / Apical Tri-Bag Float
Compatible

Start Date: 2/28/14

Required Date: 3/14/14

AN3C36A Purchased No 230 Each 122.0000 4 4

Start Qty: 1.00

Required Qty: 1.00

AN3C36A
Bolt

**

all sublog

Location	Loc Qty	Loc Code
FG	25	
101261	4	
122204	11	
124827	10	
ST354	2	
m127578	2	
ST514	95	
m127769	95	

AN3C37A Purchased No 230 Each 67.0000 1

AN3C37A
BOLT

**

G m128491 **DAS 26 9-89**

DAS 31 9-89

Location	Loc Qty	Loc Code
ST353	67	
M124131	1	
M127823	66	

AN3C42A Purchased No 230 Each 8.0000 1

AN3C42A
Bolt

**

G m128491 14-7-2 **DAS 26 9-89**

DAS 31 9-89

Location	Loc Qty	Loc Code
FG	5	
121103	5	
ST353	3	
m123930	1	
m127300	2	

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Shop Packet Print

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Picklist Print

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Parent Item: D350-636-018

D350-636-018

Parent Item Name: Skidtube RH Run-On Landing Wearplates Air Cruiser / Apical Tri-Bag Float Compatible

Start Date: 2/28/14

Required Date: 3/14/14

D3488-042

Manufactured No

230 Each

14.0000 1 1

Start Qty: 1.00 Required Qty: 1.00

D3488-042

Blade Fitting RH

**

11/10/10

Location

Loc Qty

Loc Code

FP001

14

106658

6

109134

1

109911

4

98887

3

D3490-5

Manufactured No

230 Each

96.0000 4 4

D3490-5

Cross Bolt Spacer

**

8614/03/25

Location

Loc Qty

Loc Code

LG001

96

101067

6

104851

49

109104

41

D3492-1

Manufactured No

230 Each

364.0000 8 8

D3492-1

Plug

**

11/10/10

Location

Loc Qty

Loc Code

FP001

364

111578

164

112738

200

D3492-5

Manufactured No

230 Each

144.0000 8 8

D3492-5

Plug

**

11/10/10

Location

Loc Qty

Loc Code

FP001

144

104854

65

105612

79

X6

X2

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Shop Packet Print

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Work Order ID: 113958

113958

Parent Item: D350-636-018

D350-636-018

Parent Item Name: Skidtube RH Run-On Landing Wearplates Air Cruiser / Apical Tri-Bag Float Compatible

Start Date: 2/28/14

Required Date: 3/14/14

D3873-1 Manufactured No 230 Each 330.0000 7 7
D3873-1 Start Qty: 1.00 Required Qty: 1.00
 Bushing ** HL 14/04/09

Location	Loc Qty	Loc Code
ST067	330	
104858	28	
105611	301	
109110	1	

D4154-041 Manufactured No 230 Each 8.0000 1 1
D4154-041 ** B114212 (12) HL 14/04/09
 Wearplate Assembly 4

Location	Loc Qty	Loc Code
FP002	8	
106716	1	
111473	7	

D4170-1 Manufactured No 230 Each 159.0000 4 4
D4170-1 ** BE14-03-25
 Bushing

Location	Loc Qty	Loc Code
LG	20	
111576	20	
LG001	139	
107681	14	
107896	125	

D4171-1 Manufactured No 230 Each 29.0000 1 1
D4171-1 ** HL 14/04/09
 Bushing

Location	Loc Qty	Loc Code
ST098	29	
109144	22	
99276	7	

Picklist Print

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Work Order ID: 113958

113958

Parent Item: D350-636-018

D350-636-018

Parent Item Name: Skidtube RH Run-On Landing Wearplates Air Cruiser / Apical Tri-Bag Float Compatible

Start Date: 2/28/14

Required Date: 3/14/14

MS21043-3 Purchased No 230 Each 352.0000 Start Qty: 1.00 Required Qty: 1.00
 Nut ***MS21043-3*** ** u u l o u l o g

Location	Loc Qty	Loc Code
FG	80	M120398
103691	80	
ST315	272	
124555	59	
m126741	213	

NAS1149C0363R Purchased No 230 Each 976.0000 9 ***NAS1149C0363R*** ** u u l o u l o g
 Washer *

Location	Loc Qty	Loc Code
FP001	698	
114742	698	
ST292	278	
122441	278	

NAS1515H3L Purchased No 230 Each 386.0000 4 ***NAS1515H3L *** ** u u l o u l o g
 Washer

Location	Loc Qty	Loc Code
FG	36	
102472	36	
ST297	350	
m127831	350	

Picklist Print

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Page 6

Work Order ID: 113958

113958

Parent Item: D350-636-018

D350-636-018

Parent Item Name: Skidtube RH Run-On Landing Wearplates Air Cruiser / Apical Tri-Bag Float
Compatible

Start Date: 2/28/14

Required Date: 3/14/14

NAS1611-005 Purchased No 230 Each 192.0000 8 8

Start Qty: 1.00

Required Qty: 1.00

NAS1611-005

O-RING

**

ll uloulo

Location

Loc Qty

Loc Code

FP001

192

m125807

4

m126974

188

NAS1611-010 Purchased No 230 Each 7.0000 8 8

NAS1611-010

O-RING

**

ll uloulo

Location

Loc Qty

Loc Code

FP001

7

m126988

3

m127813

4

M128375

x6

NAS1149D0863J Purchased No 250 Each 961.0000 2 2

NAS1149D0863.J

Washer

**

ll uloulo

Location

Loc Qty

Loc Code

FP001

2

118078

2

ST293

159

123900

6

125484

153

ST510a

800

125268

600

125635

200

x2

February-28-14 7:42:09 AM

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Page 6

Picklist Print

February-28-14 7:42:09 AM

Page 7

Work Order ID: 113958

113958

Parent Item: D350-636-018

D350-636-018

Parent Item Name: Skidtube RH Run-On Landing Wearplates Air Cruiser / Apical Tri-Bag Float Compatible

Start Date: 2/28/14

Required Date: 3/14/14

D2744 Manufactured No 110 Each 16.0000 1 1

Start Qty: 1.00

Required Qty: 1.00

D2744

Cap

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
LG001	16	
100398	15	
97543	1	

1

D2600-3-BENT

Manufactured No

110 Each 17.0000 1 1

D2600-3-BENT

Extrusion Bent

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
LG	17	
111091	10	
111606	7	

1

D2743

Manufactured No

160 Each 305.0000 8 8

D2743

Crossbolt Spacer

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
LG	288	
111570	167	
112729	121	
LG001	17	
109799	17	

8

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February-28-14 7:42:10 AM

Page 8

Work Order ID: 113958

113958

Parent Item: D350-636-018

D350-636-018

Parent Item Name: Skidtube RH Run-On Landing Wearplates Air Cruiser / Apical Tri-Bag Float Compatible

Start Date: 2/28/14

Required Date: 3/14/14

D2739 Manufactured No 160 Each 18.0000 1 1

Start Qty: 1.00

Required Qty: 1.00

D2739

350 I Beam

Location	Loc Qty	Loc Code
LG 11094	7	
110835	4	
111609	3	
LG002	11	
109973	3	
112596	8	

① DGL/JL 11-24

ALS4-1032-225 AELS8-1032-225 Purchased No 230 Each 1,240.000 4 4

ALS4-1032-225

Rivnut

Location	Loc Qty	Loc Code
FG	30	
M127028	30	
ST280	1176	
M127028	10	
M128179	1166	
st555	34	
M127092	34	

ll w/outline

AN8C35A Purchased No 230 Each 99.0000 1 1

AN8C35A

Bolt

Location	Loc Qty	Loc Code
FG	4	
121275	4	
FP001	95	
m126293	29	
m127061	16	
m127823	50	

ll w/outline

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Page 9

Work Order ID: 113958

113958

Parent Item: D350-636-018

D350-636-018

Parent Item Name: Skidtube RH Run-On Landing Wearplates Air Cruiser / Apical Tri-Bag Float Compatible

Start Date: 2/28/14

Required Date: 3/14/14

AN6C44A Purchased No 230 Each 170.0000 4 4

Start Qty: 1.00

Required Qty: 1.00

AN6C44A

Bolt

**

ll wlooloo

Location

Loc Qty

Loc Code

FG 2
103964 2
ST341 168
m128319 168

MS21083C8 Purchased No 230 Each 106.0000 1 1

MS21083C8

Nut

**

ll wlooloo

Location

Loc Qty

Loc Code

ST319 106
m124308 6
m127255 6
m127813 25
m128119 69

D3631-1 Manufactured No 230 Each 320.0000 8 8

D3631-1

Washer

**

ll wlooloo

Location

Loc Qty

Loc Code

FP001 320
110258 16
111019 100
111546 104
113164 100

Picklist Print

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Page 10

Work Order ID: 113958

113958

Parent Item: D350-636-018

D350-636-018

Parent Item Name: Skidtube RH Run-On Landing Wearplates Air Cruiser / Apical Tri-Bag Float Compatible

Start Date: 2/28/14

Required Date: 3/14/14

NAS1149C0332R Purchased No 230 Each 8,074.000 4 4

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0332R
WASHER

**

ll idolog

Location

Loc Qty

Loc Code

GA	1125
125654	1125
st510	6949
m126319	89
m127306	2500
m127410	3000
m127831	1360

1128591

xd

D2745 Manufactured No 230 Each 284.0000 8 8

D2745
Bushing

**

ll idolog

Location

Loc Qty

Loc Code

ST017	284
107336	100
110526	4
111554	180

VB

NAS1149C0832R Purchased No 230 Each 334.0000 1 1

NAS1149C0832R
Washer

**

ll idolog

Location

Loc Qty

Loc Code

ST292	334
122441	67
m114915	117
m125807	150

xl

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Work Order ID: 113958

113958

Parent Item: D350-636-018

D350-636-018

Parent Item Name: Skidtube RH Run-On Landing Wearplates Air Cruiser / Apical Tri-Bag Float Compatible

Start Date: 2/28/14

Required Date: 3/14/14

AN3C6A

Purchased

No

230

Each

489.0000

Start Qty: 1.00

4

4

Required Qty: 1.00

AN3C6A

Bolt

**

11/08/09

Location

Loc Qty

Loc Code

FG

10

122416

10

ST351

100

m128224

100

ST513

379

m125709

379

MS21043-6

Purchased

No

230

Each

410.0000

4

4

MS21043-6

NUT

**

11/08/09

Location

Loc Qty

Loc Code

FG

20

103693

20

ST315

140

m127255

140

ST509

250

m127813

250

D3493-1

Manufactured

No

250

Each

297.0000

2

2

D3493-1

Washer

**

14-7-2

DAS
28
9-89

DAS
31
9-89

Location

Loc Qty

Loc Code

FG

10

97201

10

ST051

287

107916

46

109105

159

112741

80

97201

2

DAS
28
9-89

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Page 12

Work Order ID: 113958

113958

Parent Item: D350-636-018

D350-636-018

Parent Item Name: Skidtube RH Run-On Landing Wearplates Air Cruiser / Apical Tri-Bag Float Compatible

Start Date: 2/28/14

Required Date: 3/14/14

MS21083C8

Purchased

No

250

Each

Start Qty: 1.00
106.0000 2 2

Required Qty: 1.00

MS21083C8

Nut

**

Handwritten: 2/28/14

Location

Loc Qty

Loc Code

ST319

106

m124308

6

m127255

6

m127813

25

m128119

69

Handwritten: x2

AN8C21A

Purchased

No

250

Each

133.0000 2 2

AN8C21A

Bolt

**

Handwritten: 2/28/14

Location

Loc Qty

Loc Code

ST

2

123966

2

st339

3

m127061

3

ST342

78

m124884

3

m128319

75

ST508

50

m127823

50

Handwritten: x2

Picklist Print

February-28-14 7:42:11 AM

Page 13

Work Order ID: 113958

113958

Parent Item: D350-636-018

D350-636-018

Parent Item Name: Skidtube RH Run-On Landing Wearplates Air Cruiser / Apical Tri-Bag Float
Compatible

Start Date: 2/28/14

Required Date: 3/14/14

D2741

Manufactured No

250

Each

52.0000

Start Qty: 1.00

Required Qty: 1.00

1 1

D2741

Blade

**

all 140562

Location

Loc Qty

Loc Code

FG

11

0115522

x1

100664

5

85480

1

98323

5

ST466

41

107206

5

110710

36

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D4168-041	350 SKIDTUBE ASSEMBLY, LH
	X			D4168-042	350 SKIDTUBE ASSEMBLY, RH
		X		D4168-043	350 SKIDTUBE ASSEMBLY, LH
			X	D4168-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
8	8	8	8	D3631-1	WASHER
7	7	7	7	D3873-1	BUSHING
1	1	1	1	D4154-041	WEARPLATE ASSEMBLY
1				D4168-1	SKIDTUBE WELDMENT, LH
	1			D4168-2	SKIDTUBE WELDMENT, RH
		1		D4168-3	SKIDTUBE WELDMENT, LH
			1	D4168-4	SKIDTUBE WELDMENT, RH
4	4	4	4	D4170-1	SPACER
1	1	1	1	D4171-1	BUSHING
4	4	4	4	ALS4-1032-225	INSERT
4	4	4	4	AN3C6A	BOLT
1	1	1	1	AN3C34A	BOLT
4	4	4	4	AN3C36A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
9	9	9	9	AN960C10	WASHER (OR NAS1149CO363R)
4	4	4	4	AN960C10L	WASHER (OR NAS1149CO332R)
1	1	1	1	AN960C816L	WASHER (OR NAS1149CO832R)
5	5	5	5	MS21043-3	NUT
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

GENERAL NOTES:

- MATERIAL: MAKE D4168-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
STANDARD: PRIME (REF. 4.2.1.3.3) AND PAINT WHITE PER DART QSI 005 4.2.
A OPTIONAL: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3.
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D4168-041/-042/-043/-044 = 32.3 LBS.
- WELD PER DART QSI 004
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY. CLEAN EXCESS OFF FINISH WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

113958 MLS
14-02-28

RELEASED
2013-08-13
MD

B	ADD VIEW TO CONTROL FWD BEND ORIENTATION (ZN D-1-4/-5/-6/-7); UPDATED FINISH OPTIONS. REASON: PAR13-276 AND NCR13-2757	MB	13.07.11
A	NEW ISSUE	SC	10.08.09
REV.	DESCRIPTION	BY	DATE
DESIGN	SC		
DRAWN	SC		
CHECKED	SC		
MFG. APPR.	SC		
APPROVED	SC		
DE APPR.	SC		
DATE	13.07.11		

DART AEROSPACE USA, INC. KENT, WA	
DRAWING NO. D4168	REV. B
TITLE 350 SKIDTUBE ASSEMBLY	SHEET 1 OF 11
SCALE NTS	
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8 7 6 5 4 3 2 1

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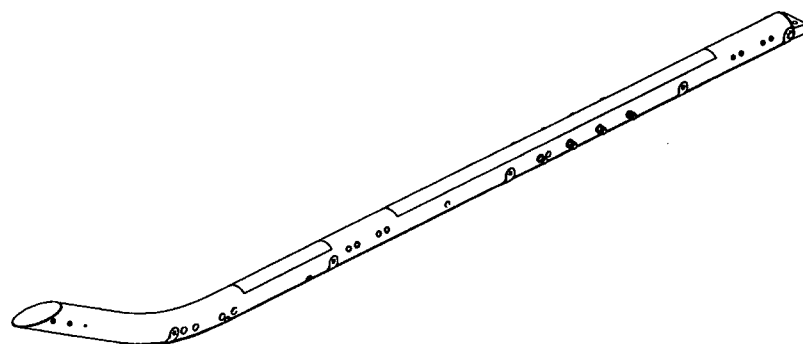
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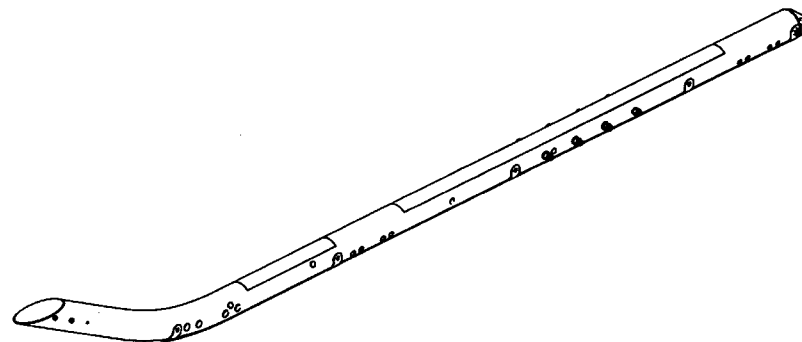
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A



D4168-041 350 SKIDTUBE ASSEMBLY, LH

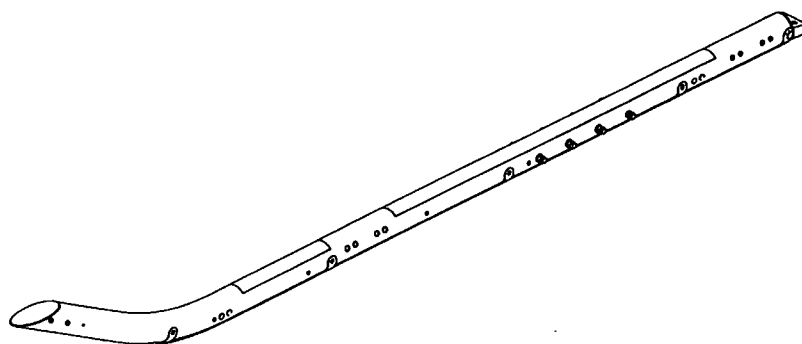


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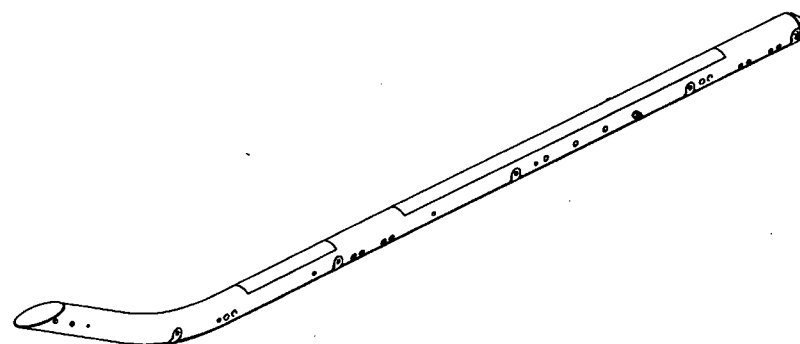
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2013-08-13
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DRAWN	<i>[Signature]</i>	KENT, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D4168	SHEET 2 OF 11
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	350 SKIDTUBE ASSEMBLY	NTS
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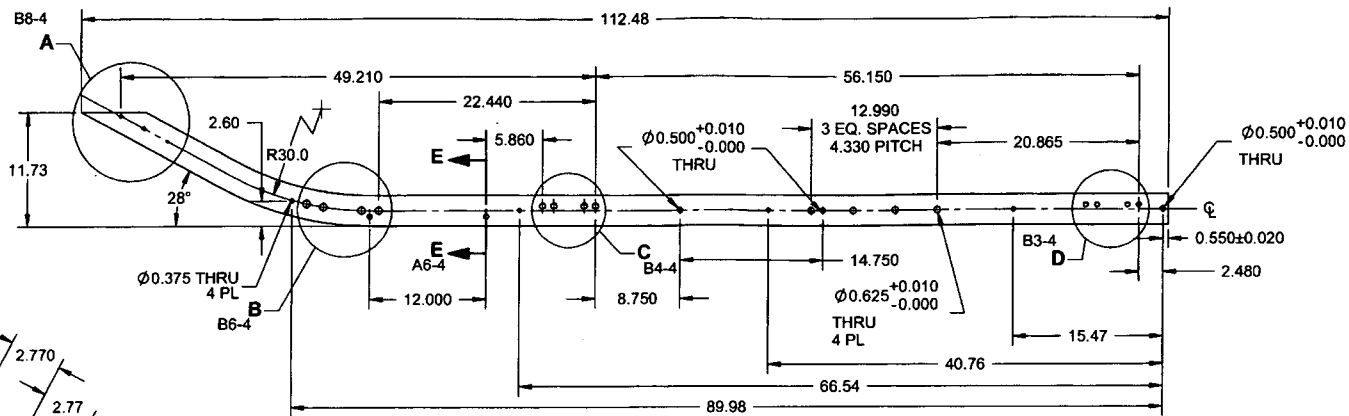
D4168-043 350 SKIDTUBE ASSEMBLY, LH



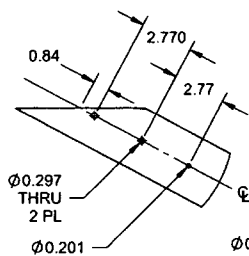
D4168-044 350 SKIDTUBE ASSEMBLY, RH

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2013-08-13
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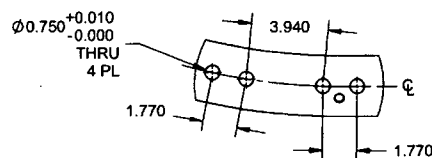
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CHECKED	<i>[Signature]</i>		SCALE
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APPROVED	<i>[Signature]</i>		
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DATE	13.07.11		



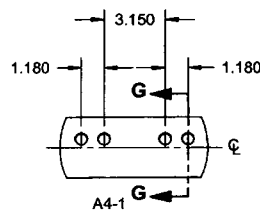
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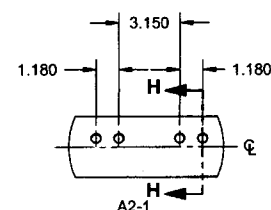
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SCALE 2X



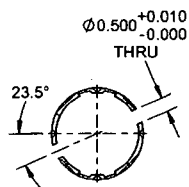
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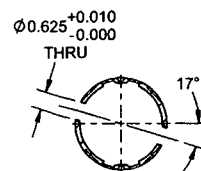
DETAIL C
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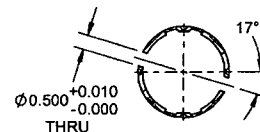
DETAIL D
SCALE 2X



SECTION E-E
SCALE 3X, 2 PL



SECTION G-G
SCALE 3X, 4 PL



SECTION H-H
SCALE 3X, 4 PL

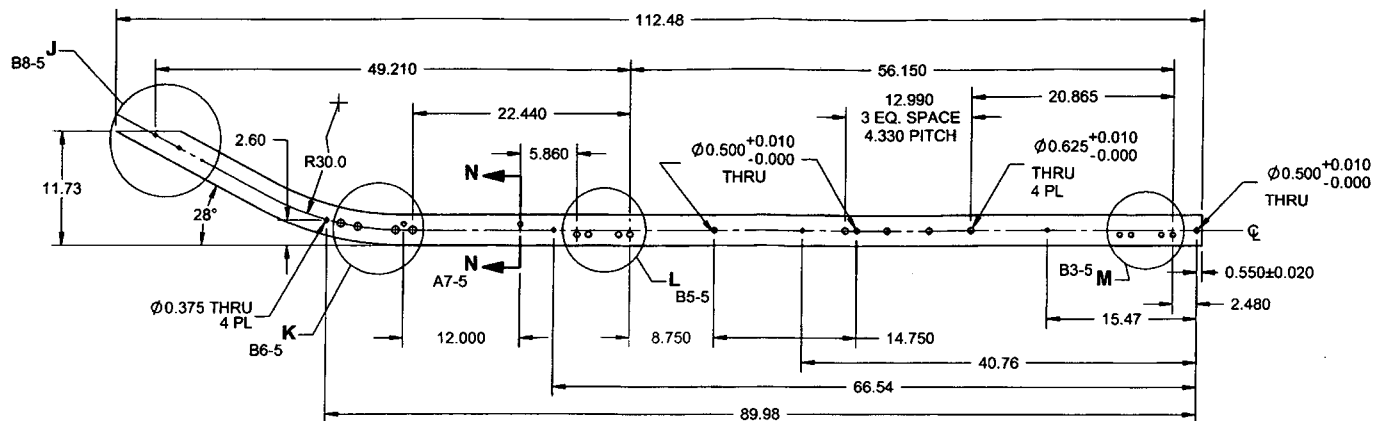
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KENT, WA

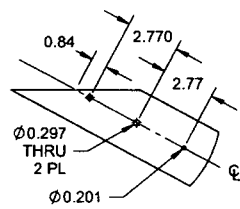
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TITLE 350 SKIDTUBE ASSEMBLY
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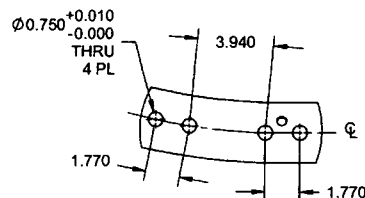
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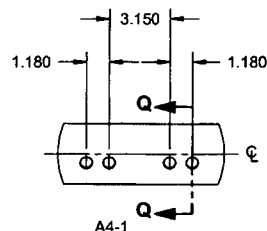
D4168-2 RH SKIDTUBE



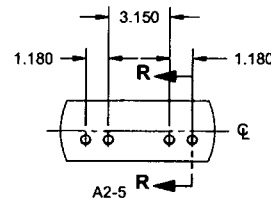
DETAIL J
SCALE 2X



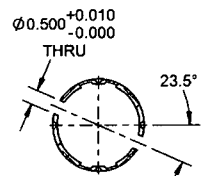
DETAIL K
SCALE 2X



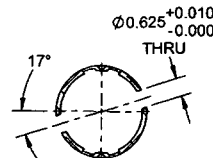
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SCALE 2X



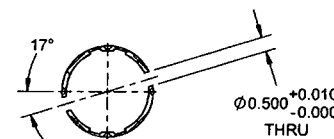
DETAIL M
SCALE 2X



SECTION N-N
SCALE 3X, 2 PL



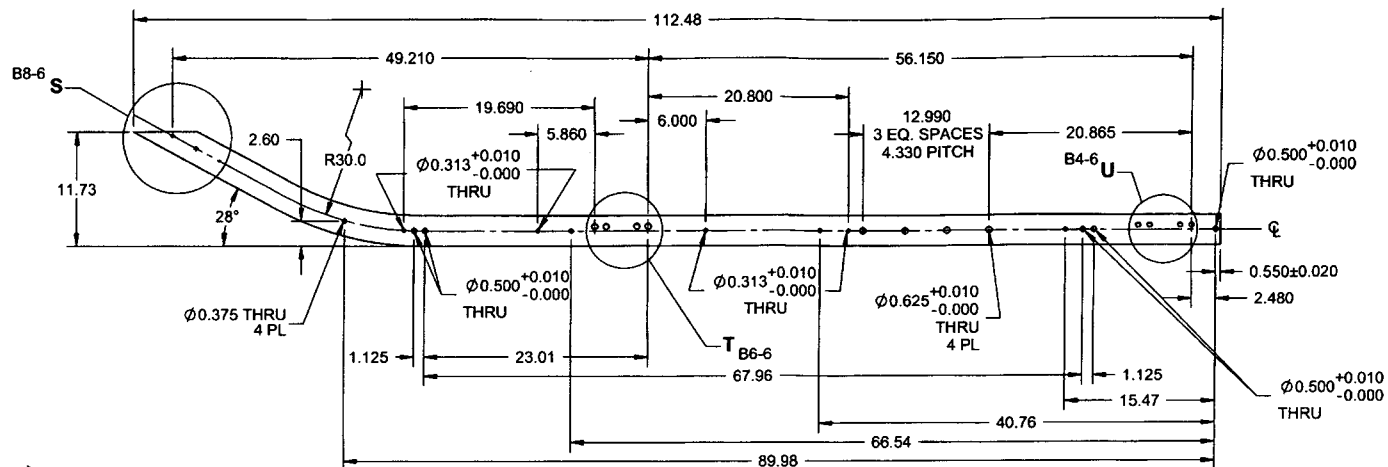
SECTION Q-Q
SCALE 3X, 4 PL



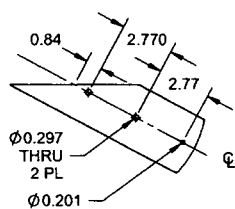
SECTION R-R
SCALE 3X, 4 PL

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2013-08-13
JW

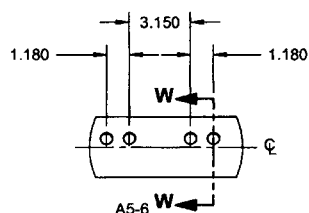
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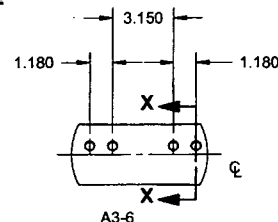
D4168-3 LH SKIDTUBE



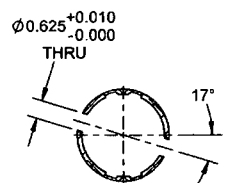
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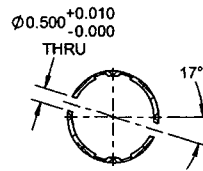
DETAIL T
SCALE 2X



DETAIL U
SCALE 2X



SECTION W-W
SCALE 3X, 4 PL



SECTION X-X
SCALE 3X, 4 PL

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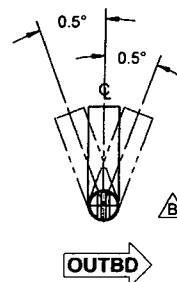
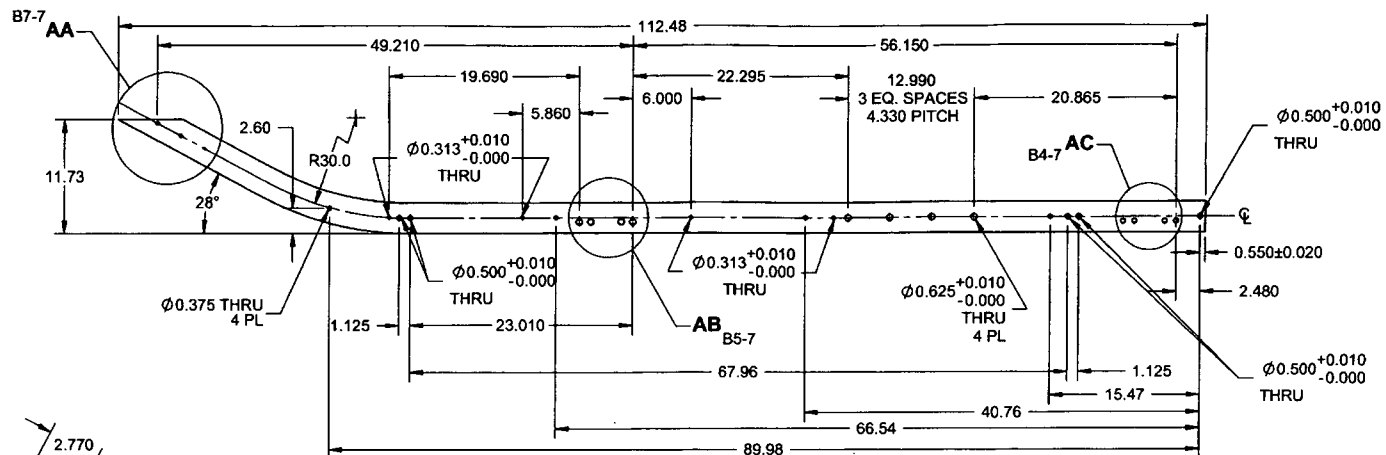
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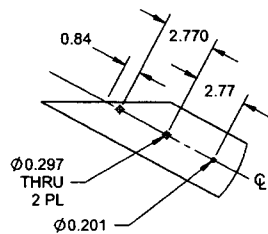
DRAWING NO.
D4168
TITLE
350 SKIDTUBE ASSEMBLY

REV. B
SHEET 6 OF 11
SCALE
NTS
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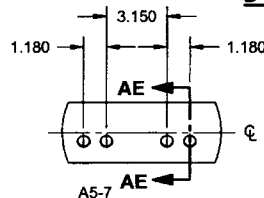
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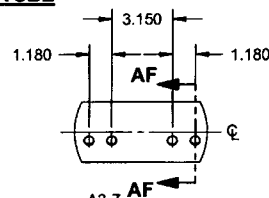
MAX ALLOWABLE
TWIST ON FWD BEND
(VIEWED LOOKING FWD)



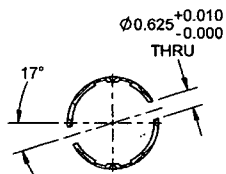
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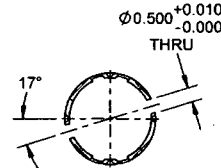
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DETAIL AC
SCALE 2X



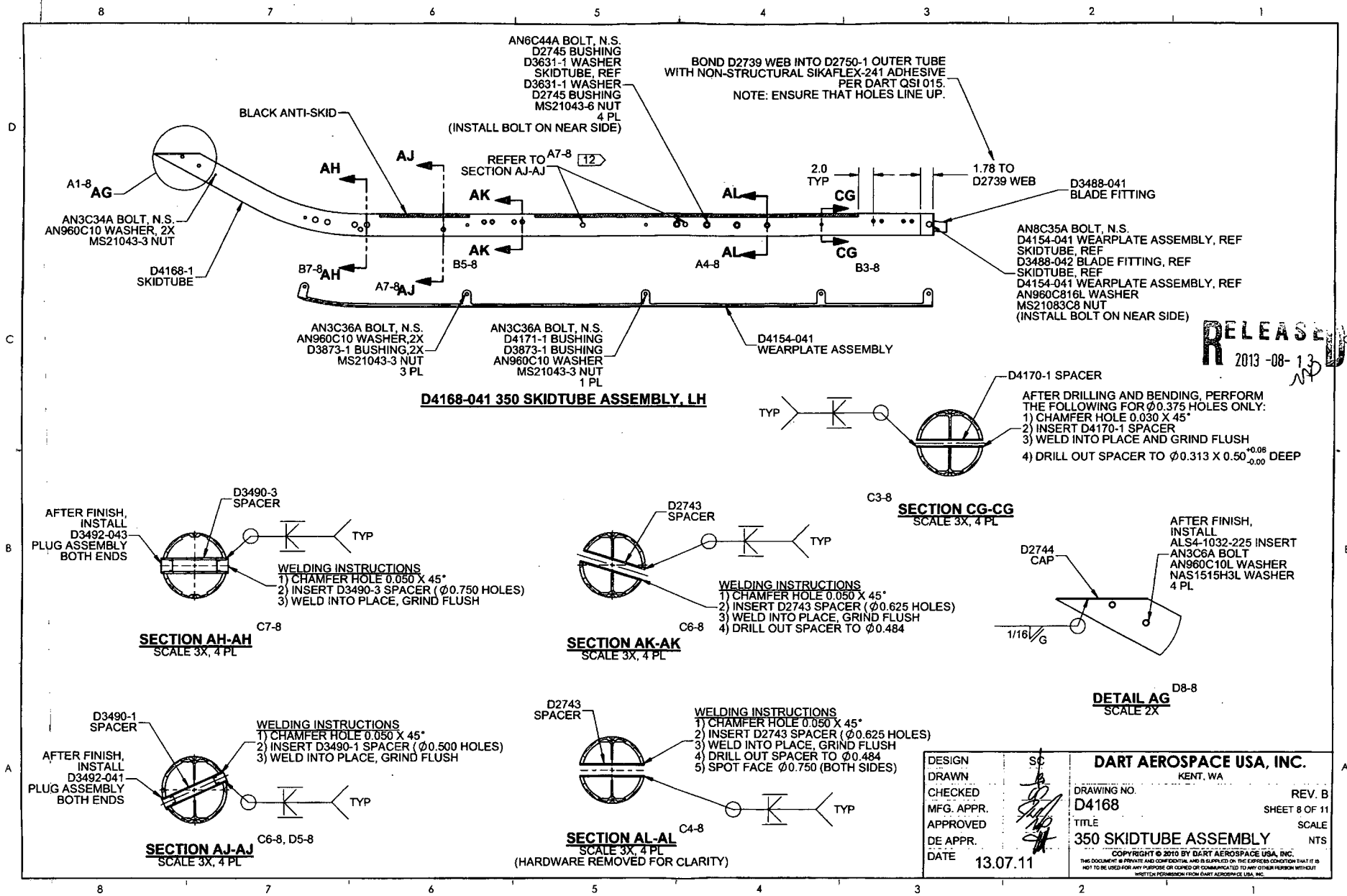
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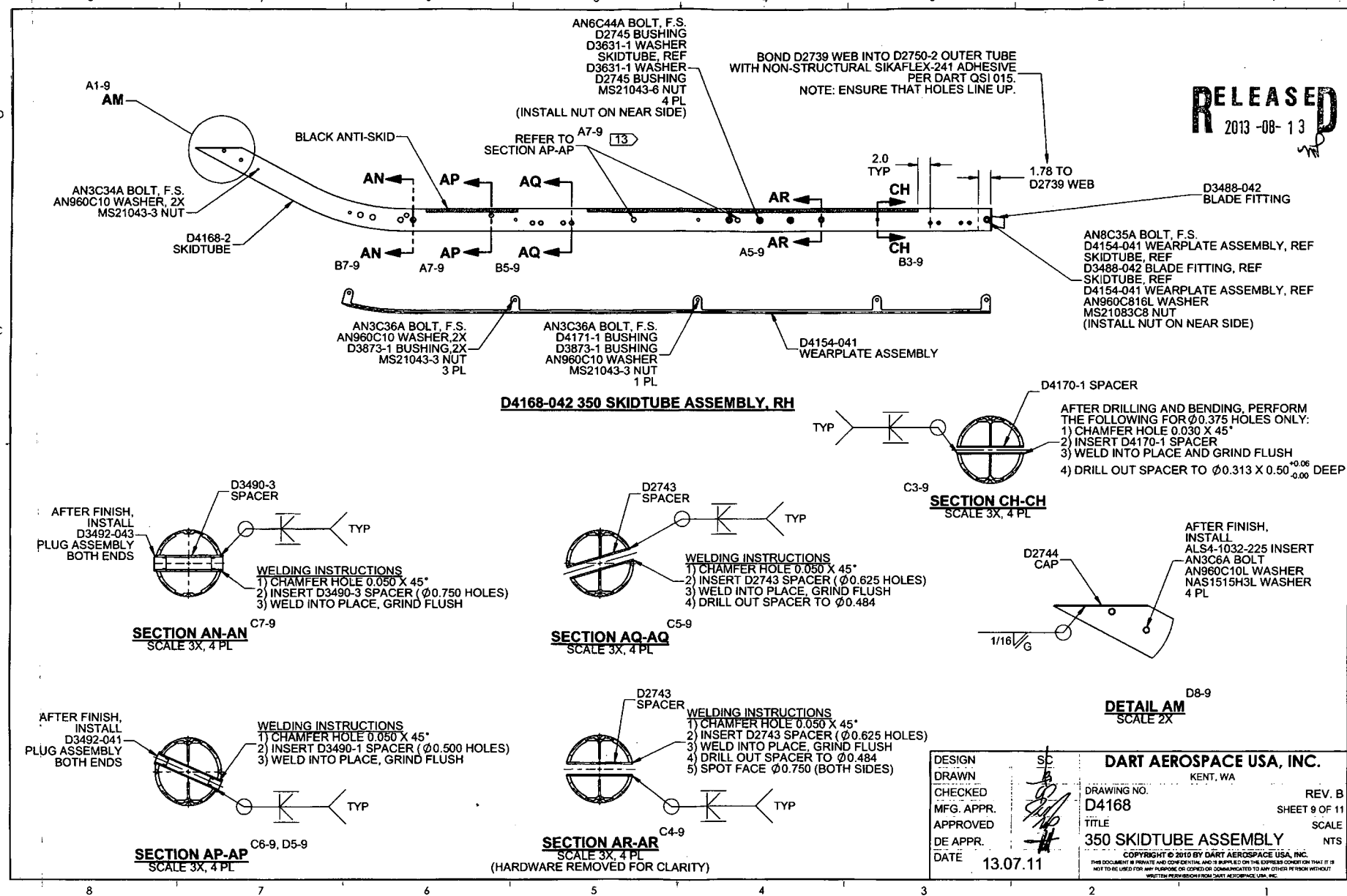
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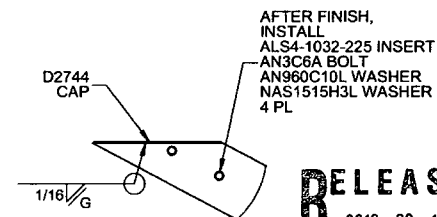
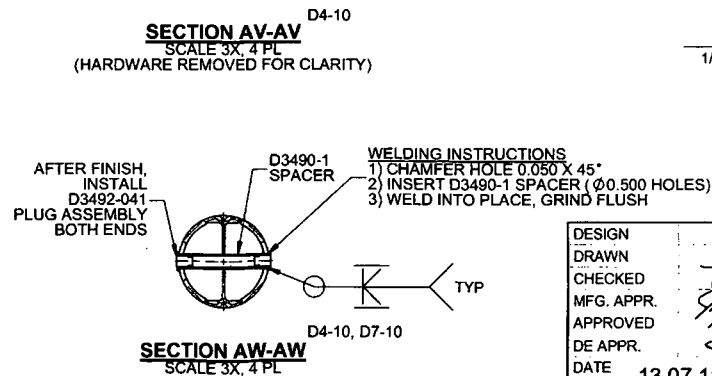
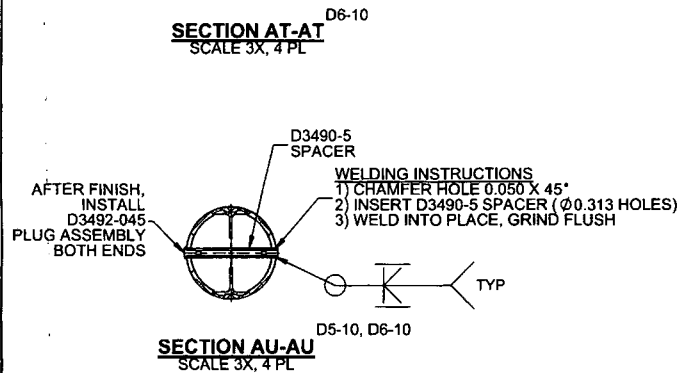
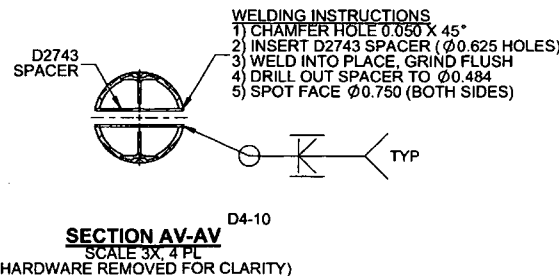
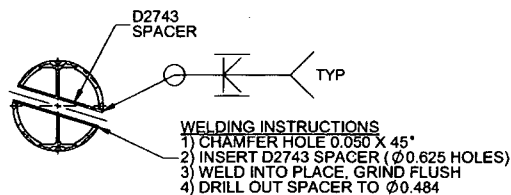
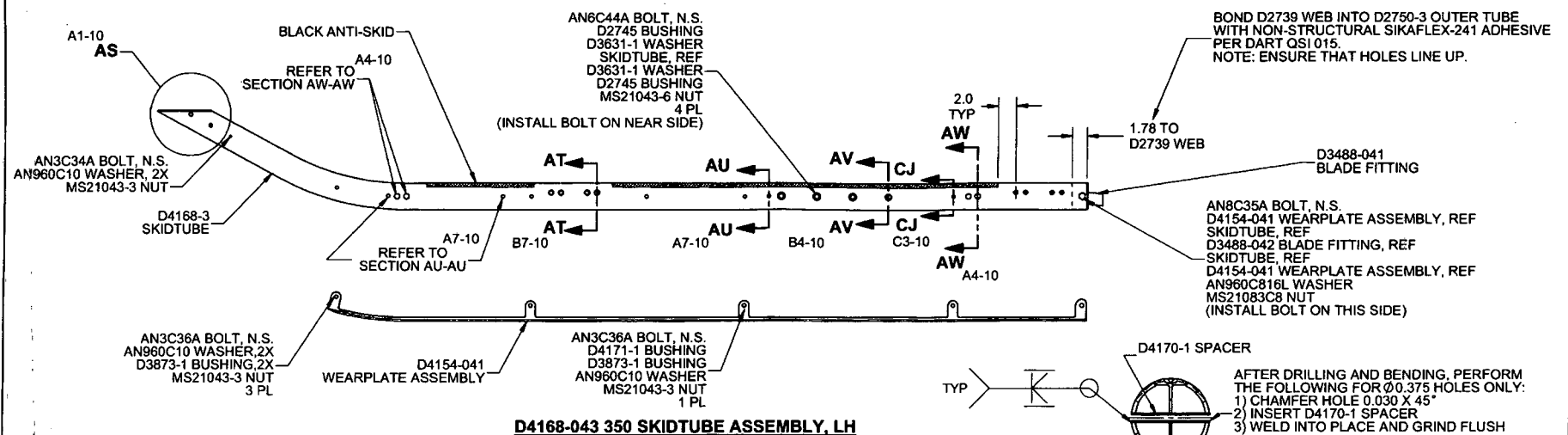
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DE APPR.	JP		NTS
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		D4168	
		350 SKIDTUBE ASSEMBLY	
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DATE	13.07.11		

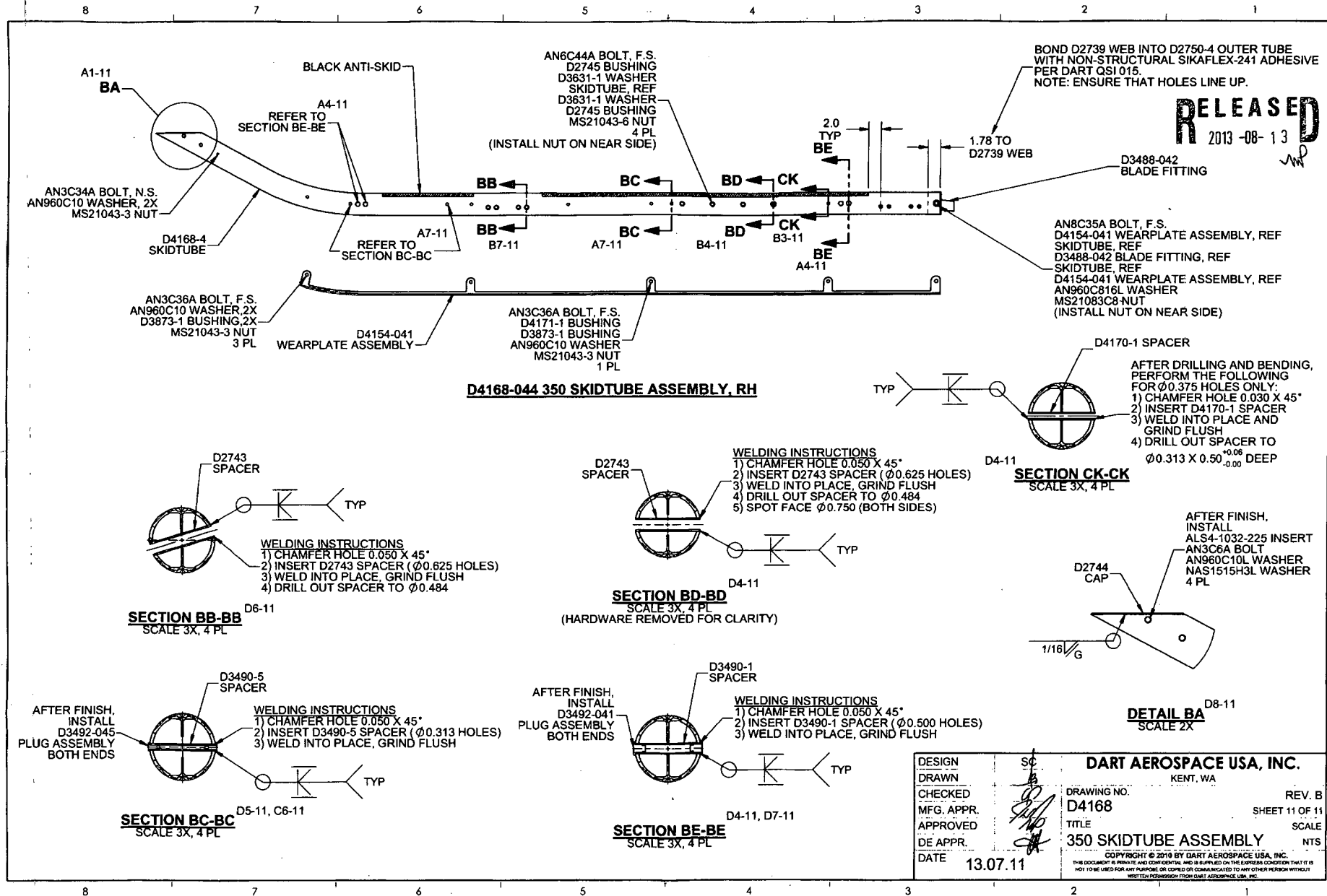


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		SC		NTS	

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DATE 13.07.11		SC		TITLE 350 SKIDTUBE ASSEMBLY	
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Linda Lacelle

From: Patrick Smith
Sent: May-29-14 1:29 PM
To: Linda Lacelle; Mike Petsche
Cc: Nigel Forbes; Eric Downing; Nancy MacLeod; David Shepherd
Subject: RE: 350 skids and 206 skids

PAR 14-338

Linda,

I spoke with David and he would allow us to use a RTV product to bond the Plugs into the Skidtube.

The existing Plugs would require:

- 1) Removal from the Skidtube
- 2) Removal of the current O-Ring
- 3) Cleaning with Alcohol
- 4) Installation of NEW O-Ring
- 5) Generous coating of the RTV
- 6) Insertion of plug into the Spacer
- 7) Clean up of exterior of Skidtube.

Pat

From: Linda Lacelle
Sent: May-29-14 10:21 AM
To: Mike Petsche
Cc: Nigel Forbes; Patrick Smith; Eric Downing; Nancy MacLeod
Subject: 350 skids and 206 skids
Importance: High

I heard yesterday that plugs were falling out. Today we were told that we cannot ship any 350 skids. We have an order to ship today, has there been a solution found to fix this problem? Can we not just sikaflex them in or something? We need to let the customer know if his order is shipping or not...

Thx

Linda

[Handwritten signature]